

Work Order ID 164087

Thursday, July 13, 2017 11:48:22 AM

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Item ID: D4780-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Cover Mounting Bracket Assembly
 Start Date: 7/12/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/19/2017 Req'd Qty: 2.00 ***2*** Customer:

Reference: **DAS**
 Approvals: Process Plan: **21** Date: **JUL 13 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4780	A

100 FLOW WATER JET 0.07

100
 Waterjet Memo 0.17
 FLOW CNC Waterjet 1-Cut D4780-1 as per Dwg
 Dwg Rev: **A**
 Prog Rev: **A**
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110
 QC Memo 0.02
 Quality Control

120 QC8- Inspect parts - second check 0.00

120
 QC Memo 0.04
 Quality Control

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Memo

Stamp
17/07/89
DA
69
69

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D46
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 9-86
 JUL 18 2017

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.23							
Hand Finishing									
165	QC7-Inspect Chemical Conversion Coat	0.00							
165									
QC	Memo	0.02							
Quality Control									
170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.11							
Powder Coating	START TIME: 3:40 OVEN TEMPERATURE: 300 FINISH TIME: 4:10								

x2 **0** **20170727**
BEB

2 **0** **170731** **34**

2 **0** **17-07-31** **34**

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Item ID: D4780-041 Accept *N900040100* Setup Start *NS1*
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <i>51/25</i>	0.00							
210									
Packaging	Memo	0.02				<i>2</i>			DAS 66 9-89
Packaging									
									AUG 0 / 2017
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.20							<i>17/8/2</i>
Quality Control									

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Picklist Print

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Parent Item: D4780-041

D4780-041

Parent Item Name: Fwd Cover Mounting Bracket Assembly

Start Date: 7/12/2017

Required Date: 7/19/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased			No	100	sf	74.9701	0.0722	0.152			

M6061T6S 032

6061-T6 Sheet 0.032"

**

07/17/15

Location	Loc Qty	Loc Code
MAT021	74.970063	
m131352	0.000037	
m135724	42.703526	
m136942	32.2665	

MS20426AD3-4

Purchased

No

190

Each

7,458.000

4

8

MS20426AD3-4

RIVET

**

17/08/01

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Location	Loc Qty	Loc Code
GA	5872	
m134294	1921	
m136444	3951	
ST312	1586	
m134294	1586	

MS21059L3

Purchased

No

190

Each

172.0000

2

4

MS21059L 3

Nut Plate

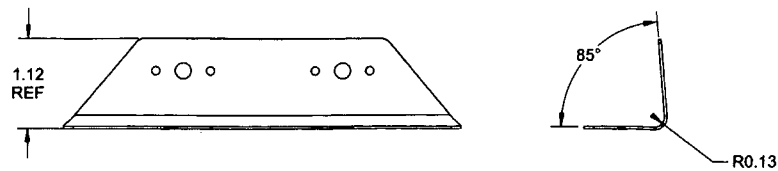
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17/08/01

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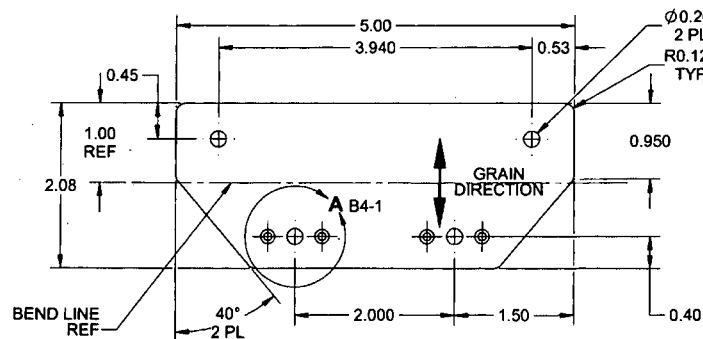
Location	Loc Qty	Loc Code
GA	75	
M137412	1	
M137659	30	
M137710	44	
ST301	97	
M137587	4	
M137820	43	
M137963	50	

QTY -041	P/N	DESCRIPTION
X	D4780-041	FWD COVER MOUNTING BRACKET ASSY
1	D4780-1	FWD COVER MOUNTING BRACKET
4	MS20426AD3-4	RIVET, CSK
2	MS21059L3	NUTPLATE

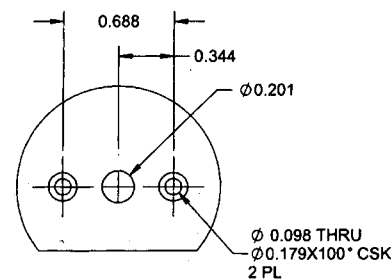


D4780-1 FWD COVER MOUNTING BRACKET
(MAKE FROM D4780-1F)

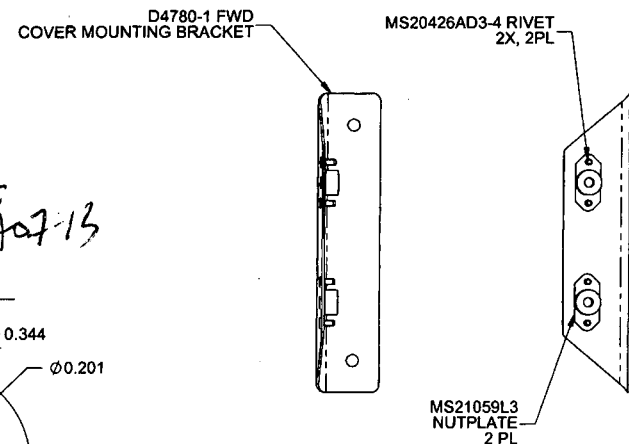
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *164087 MJS 1A07-13*



D4780-1F FLAT PATTERN



DETAIL A B7-1
SCALE 2X
2 PL



D4780-041 FWD COVER MOUNTING BRACKET ASSY

RELEASED
2013-03-11

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032" THICK, PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF. DART SPEC. M6061T6S.032)
- 2) FINISH: D4780-1F: NONE
D4780-041: CHEMICAL CONVERSION COATING PER DART QSI 005 4.1, POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3, D4780-041: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4780-041" AND B/N USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 METHOD 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PROFILE PER DRAWING FILE "D4780-1F-REVA.DXF"

A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	MP	D4780	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	FWD COVER MOUNTING BRACKET ASSY	NTS
DATE	13.03.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	